

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
690 Walnut Ave.St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 1.28**WELDING INSPECTION REPORT****Resident Engineer:** Casey, William**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-027961**Date Inspected:** 14-Jul-2012**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1530**Contractor:** American Bridge/Fluor Enterprises, a JV**Location:** jobsite**CWI Name:** William Sherwood**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG**Summary of Items Observed:**

At the start of the shift this Quality Assurance Inspector (QA) traveled to the SAS project site and observed the work and the inspection performed by American Bridge/Fluor Enterprises (AB/F) welding and Quality Control (QC) personnel. The observations and inspections were performed as noted below:

12W OBG Corner Drop-In

This QAI observed Welder Tran Chau using a rosebud torch to preheat splice 12W-W2.1-B1 to a QC recorded, QA verified temperature of 150F. Preheat temperature was measured using a Tempil Stick. This QAI noted QC William Sherwood recording preheat temperature whenever there was a stop in work.

QAI witnessed the welding of 12W-W2.1-C1 by welder Tran Chau utilizing the Shield Metal Arc Welding Process in the 1G position using E7018 consumable electrodes. The QC recorded and this QAI verified that the weld metal was being deposited to the parameters of Welding Procedure Specification ABF-WPS-D15-1040C-CU.

Welder Chau was observed using the stringer method and good workmanship practices in regard to interpass cleaning.

This QAI observed the contractor using Miller induction heating blankets to maintain a constant 200F preheat during Flux Cored Arc Welding operations. This QAI observed Steve Jensen checking with an infrared thermometer and recording preheat at regular intervals during welding operations. This QAI verified the preheat temperature at numerous time through the shift.

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QAI witnessed the welding of splice 12W-W2.1-C1 by welder Jin Pai Wang (ID#7299) utilizing the Flux Cored Arc welding process in the 1G position using E71-T-1M consumable electrodes. The QC recorded and this QAI verified that the weld metal was being deposited to the parameters of Welding Procedure Specification ABF-WPS-D15-3040A-1. Welder Wang was observed using the stringer method and good workmanship practices in regard to interpass cleaning.

QAI witnessed the welding of splice 12W-W2.1-C1 by welder Kiao Jian Wan (ID#9677) utilizing the Flux Cored Arc welding process in the 1G position using E71-T-1M consumable electrodes. The QC recorded and this QAI verified that the weld metal was being deposited to the parameters of Welding Procedure Specification ABF-WPS-D15-3040A-1. Welder Wan was observed using the stringer method and good workmanship practices in regard to interpass cleaning.



Summary of Conversations:

There were general conversations with Quality Control Inspector William Sherwood, at the start of the shift regarding the location of welding, inspection personnel scheduled for this shift. All observations were relayed to Bill Levell.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or

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remedial efforts please contact Nina Choy 510 385 5910, who represents the Office of Structural Materials for your project.

Inspected By:	Daggett,Matt	Quality Assurance Inspector
Reviewed By:	Levell,Bill	QA Reviewer
